

# Work Order ID 50719

July 21, 2009 12:37:52 PM



Page 1

Item ID: D3684-043  
Revision ID: C  
Item Name: MOUNT ASSEMBLY

Accept



Setup Start



Stop



Start Date: 7/15/09 Start Qty: 3.00  
Required Date: 7/15/09 Req'd Qty: 3.00



Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: *W*  
QC:

Date:  
Date:

Tooling:  
SPC (Y/N):

Date:  
Date:

Run Start  
Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3684	Rev C

100	Pick Kit	0.00
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Packaging	Memo	0.00
-----------	------	------

Packaging

*9/8/12* *QSP*

110	Small Fab	0.00
-----	-----------	------



Small Fab	Memo	0.00
-----------	------	------

Small Fab

1-Use anti-seize compound Tectly 502c Class 1,Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3684 1 2-Assemble D3684-049 & D3687-1 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3684: \*\*\*Ensure holes for AN3C Bolts are free o

*2b 09/08/12* *(3)*

120	QC5- Inspect part completeness to step on W/O	0.00
-----	---	------



QC	Memo	0.00
----	------	------

Quality Control

*2b 09/08/12*

*(+3)* *φ*

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Page 2

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Accept



Setup Start



Stop



Start Date: 7/15/09 Start Qty: 3.00



Required Date: 7/15/09 Req'd Qty: 3.00



Cust Item ID:

Customer:

Reference:

Run Start



Stop



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: 139E

0.00



Packaging

Memo

0.00

Packaging

3 9/8/12 MD

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09-08-13  
mf 09-08-13

# Picklist Print

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Work Order ID: 50719

Parent Item: D3684-043RevC

Parent Item Name: MOUNT ASSEMBLY



Comments:

Start Date: 7/15/09

Required Date: 7/15/09

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C12A		Purchased	No			110	Each	135.0000	12.0000			
												
Bolts												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	135	
106993	7	
110155	2	
110552	4	
110584	72	
111916	50	

D3684-047RevC Manufactured No

110 Each 1.0000 3.0000



FWD LEG ASS'Y

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	1	50729
45600	1	

D3684-049RevC Manufactured No

110 Each 1.0000 3.0000



AFT LEG ASS'Y

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	1	1350742
45601	1	

8/1 5/08/09/11

13 5/08/08/12

13 5/08/08/12

# Picklist Print

July 21, 2009 12:37:52 PM

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Work Order ID: 50719

Parent Item: D3684-043RevC

Parent Item Name: MOUNT ASSEMBLY



Comments:

Start Date: 7/15/09

Required Date: 7/15/09

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3687-1RevB		Manufactured	No			110	Each	12.0000	3.0000			
												
MOUNT												



Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST	12	
44683	3	
45911	1	
46760	8	

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
3

SB 07/07/11

D3692-1RevB		Manufactured	No			110	Each	106.0000	24.0000			
												
SPACER												

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST	106	
44827	68	
45672	38	

\_\_\_\_\_  
\_\_\_\_\_  
24

SB 07/08/11

July 21, 2009 12:37:52 PM

Shop Packet Print

Page 2

# Picklist Print

July 21, 2009 12:37:52 PM

Work Order ID: 50719

Parent Item: D3684-043RevC

Parent Item Name: MOUNT ASSEMBLY

Comments:

Start Date: 7/15/09

Required Date: 7/15/09

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21043-3		Purchased	No			110	Each	590.0000	12.0000			



Nut

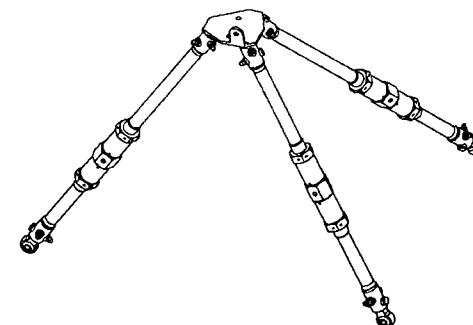
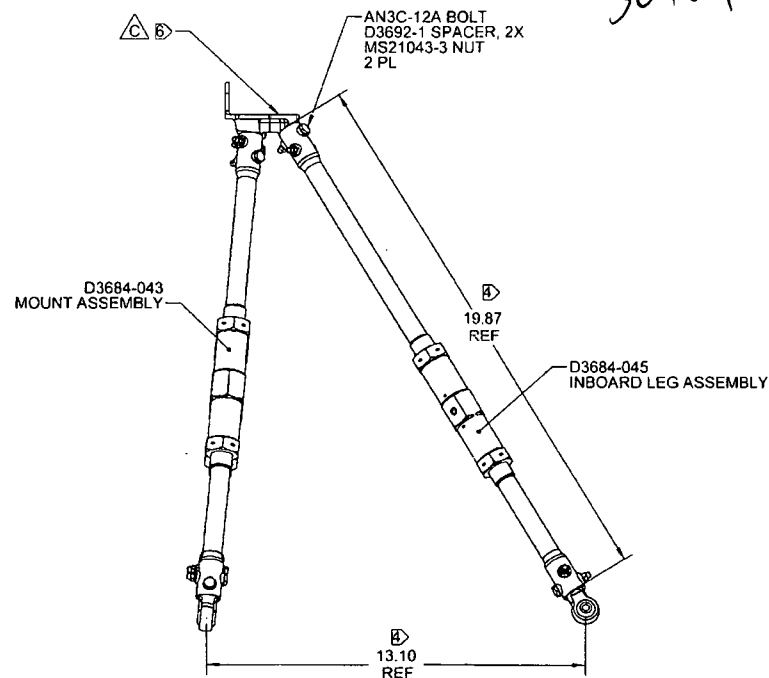


<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	80	
103691	80	
Main Warehouse		
ST	510	
111819	210	
112243	300	

12

St 07/08/11

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D3684-041	TRIPOD MOUNT ASSEMBLY
2	1	D3684-043	MOUNT ASSEMBLY
3	1	D3684-045	INBOARD LEG ASSEMBLY
4	4	D3692-1	SPACER
5	2	AN3C-12A	BOLT
6	2	MS21043-3	NUT



**D3684-041 TRIPOD MOUNT ASSY**

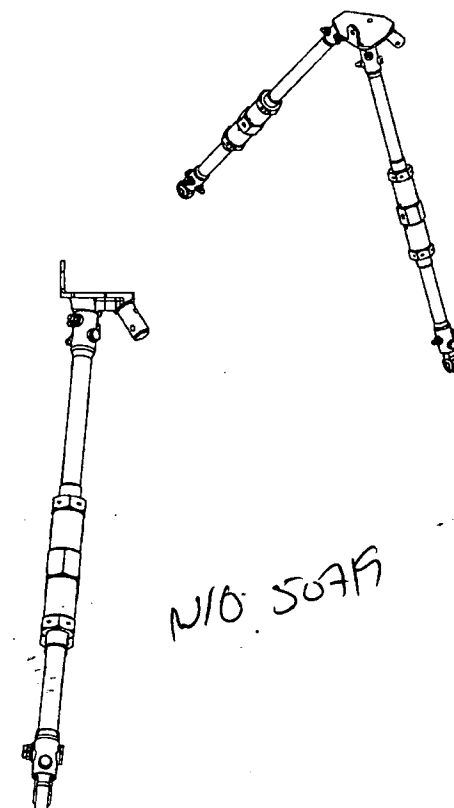
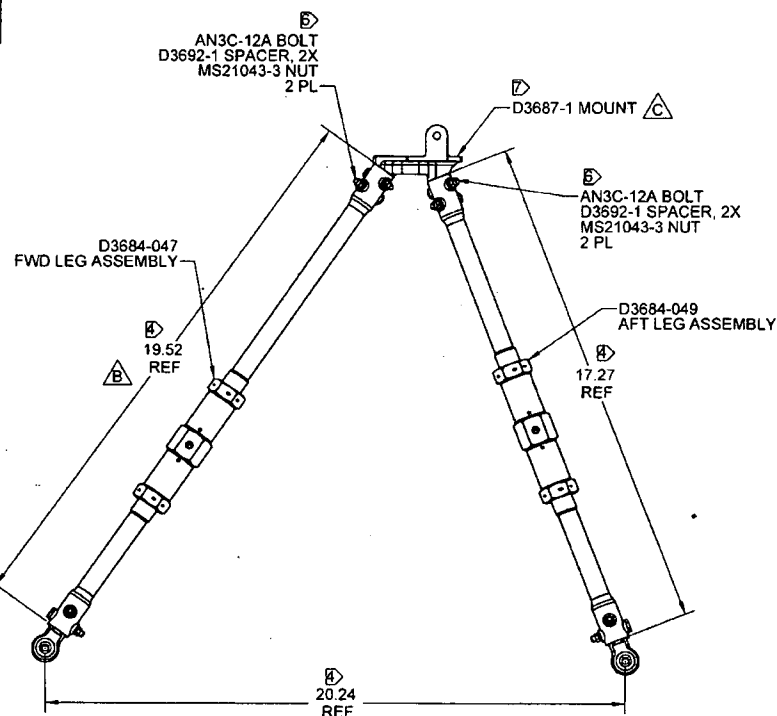
**NOTES:**

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSIONS SHOWN ARE WHEN D3688-1/-3/-5 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES
- 5) WEIGHT: 9.9 lbs
- 6) ASSEMBLE D3684-045 WITH D3684-043 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT
- 7) ASSEMBLY SHOWN FOR REF ONLY, -041 IS PACKAGED UNASSEMBLED

**RELEASED**  
08/12/15

C	NOW ASSEMBLED USING SEALANT (ZN A8-1, D6-1, A8-2, D4-2, A8-3, B4-3, A8-4, B4-4, A8-5, B5-5); ASSEMBLY NOW SHOWN FOR REF ONLY (ZN A8-1, A4-1)	RF	08.12.15
B	19.52 WAS 19.50 (ZN C6-2); 9.20 WAS 9.70 (ZN C6-2); 20.74 WAS 21.24 (ZN C5-4); 6.95 WAS 6.88 (ZMDS-5); MODIFIED PER PROTOTYPE INSTALLATION; REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3684	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TRIPOD MOUNT ASSY	NTS
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ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D3684-043	MOUNT ASSEMBLY
2	1	D3687-1	MOUNT
3	1	D3684-047	FWD LEG ASSY
4	1	D3684-049	AFT LEG ASSY
5	8	D3692-1	SPACER
6	4	AN3C-12A	BOLT
7	4	MS21043-3	NUT



N/O 5075

**D3684-043 MOUNT ASSEMBLY**

**NOTES:**

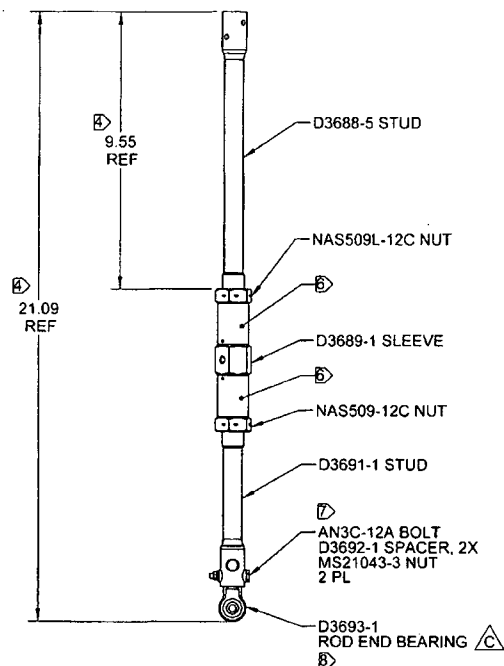
- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3684-043 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSIONS SHOWN ARE WHEN D3688-1/3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES
- 5) WEIGHT: 6.6 lbs
- 6) TORQUE FASTENERS TO 20-25 in-lbs
- 7) ASSEMBLE D3684-047 & D3684-049 WITH D3687-1 USING SIKAFLEX-241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3684	SHEET 2 OF 6
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	TRIPOD MOUNT ASSY	NTS
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**RELEASED**  
07/01/12

ITEM	QTY -045	PART NUMBER	DESCRIPTION
1	X	D3684-045	INBOARD LEG ASSEMBLY
2	1	D3688-5	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT



W1050719

**D3684-045 INBOARD LEG ASSEMBLY**

**RELEASED**  
09/01/12 MP

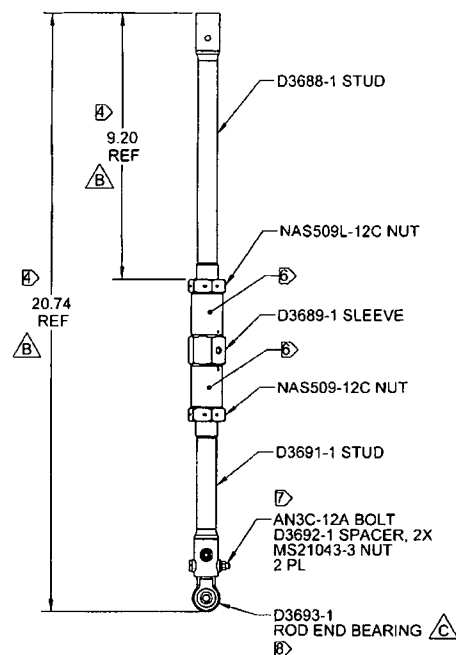
**NOTES:**

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3684-045 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSION SHOWN IS WHEN D3688-5 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.1 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-18173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D3684	REV. C
MFG. APPR.			SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TRIPOD MOUNT ASSY	NTS
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ITEM	QTY -047	PART NUMBER	DESCRIPTION
1	X	D3684-047	FWD LEG ASSEMBLY
2	1	D3688-1	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT



W/O 50719

**D3684-047 FWD LEG ASSEMBLY**

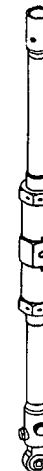
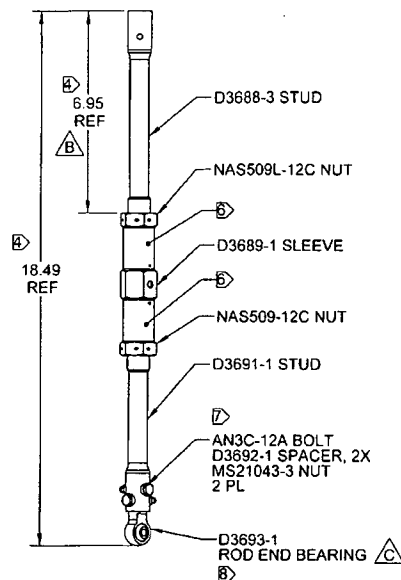
**RELEASED**  
09/01/12

**NOTES:**

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSION SHOWN IS WHEN D3688-1 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.10 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3684	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TRIPOD MOUNT ASSY	NTS
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ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D3684-049	AFT LEG ASSEMBLY
2	1	D3688-3	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT



**D3684-049 AFT LEG ASSEMBLY**

**NOTES:**

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSION SHOWN IS WHEN D3688-3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 2.88 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

W10 50719

**RELEASED**  
09/01/12 MP

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. <b>D3684</b>	REV. C
MFG. APPR.			SHEET 5 OF 5
APPROVED		TITLE <b>TRIPOD MOUNT ASSY</b>	SCALE NTS
DE APPR.			
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